

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028970**Date Inspected:** 12-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower Base Electro Slag Weld (ESW) 'T' weld joint #S-043 face A, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at location Y=3600 to Y=3950 due to UT detected defects. The ABF personnel have resumed the exploratory excavation from 54mm deep where they left off yesterday. The personnel were noted using only the disc grinder in every 1mm increments of excavation. ABF QC Steve Jensen was observed performing Magnetic Particle Testing (MT) on the following various depths with indications stated below. This QA also performed the same test and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 55mm with indications as noted below. The shift was completed up to this depth of excavation.

The starting depth of excavation on this date was a continuation from the previous shift. The results of the exploratory excavations are as follows;

1. 54mm in depth – one 22mm long linear indication at Y=3820mm, X=15mm was noted and three (3) 2 to 5mm transverse indications from Y=3650 to Y=3700mm.

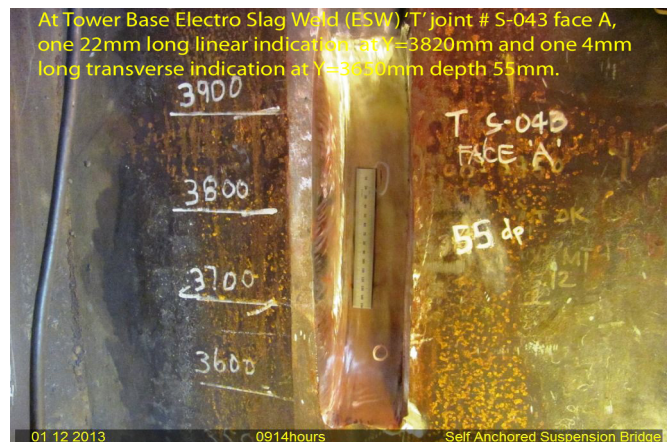
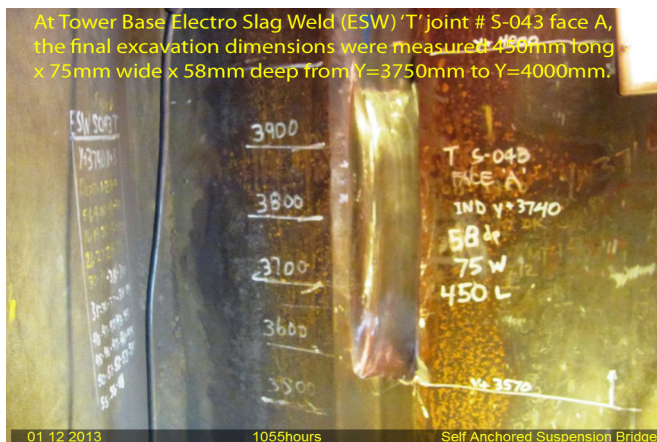
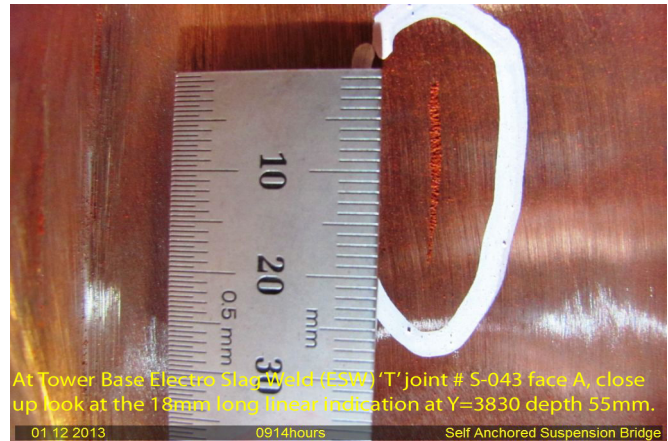
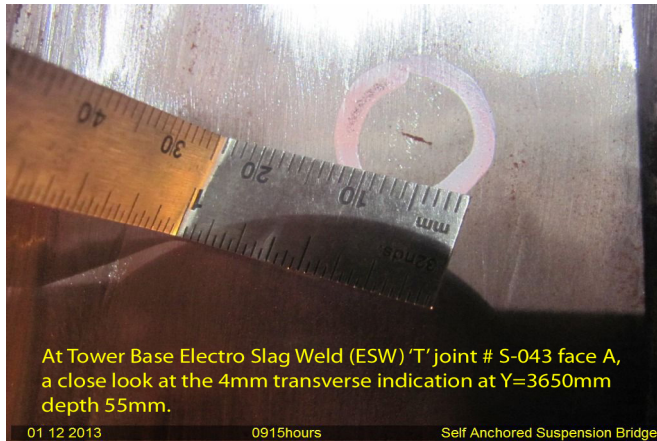
2. 55mm in depth –one 18mm long linear indication at Y=3830mm, X=15mm was noted and one 4mm transverse indication at Y=3650mm

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3. 56mm in depth – all linear and transverse indications have been removed. Final measured dimensions after the excavation was measured 450mm long x 75mm wide x 58mm deep from Y=3570 to Y=4000mm.

After the completion of the excavation at location mentioned above, the ABF personnel who were performing the excavation has moved and set up his tools at ESW 'F' joint # E-045 for the next excavation.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer